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REMARKS

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In the Outstanding Office Action Claims 1-50, 74 and 77-85 were rejected under 35 USC §112, second paragraph, as being indefinite for failing to particularly point out and distinctly claim the subject matter which Applicant regards as the invention. The terms "disposable", "tumbler", "fortified" and the phrase "biaxial toughness" were objected to. Moreover, the term "haze value" was also objected to under §112, second paragraph.

Claims 1, 77, 80 and 82 were rejected under 35 USC §102(b) as being anticipated by United States Patent No. 3,984,498 to *McChesney et al.* which relates to a blow-molded bottle made from nitrile containing polymers.

Claim 74 was rejected under 35 USC §102(b) as being anticipated by *Anderson et al.*, United State Patent NO. 5,506,046 which relates to articles made from mineral filled sheet.

Claims 2-50 were rejected as obvious over United States Patent No. 5,433,337 to *Willbrandt* which discloses an injection molded segmented "car cup". It was noted the '337 patent failed to disclose the features of Claims 2-4, 10-12, 17-21, 30-32 and 36-44.

Claims 78-79 and 81 were rejected as obvious over *McChesney et al.*, noted above and Claims 83-85 were rejected as being unpatentable over *Willbrandt* '337 in view of United States Patent No. 6,001,439 to *Kawakami et al.*

As amended, this case is believed in condition for allowance. The claims have been amended to positively recite structural features which distinguish the art. In particular, the "tumbler" of the invention has been defined as a drinking glass with an opening generally larger than the base and the "fortified" rim has been defined as a solid polymer bead having a thickness of from 1.5 to 6 (Claims 1, 2, 10, 16, 22, 30, 36, 42 and 50) or 1.1 to 4 (Claim 61) times the thickness of the adjacent sidewall of the tumbler.

Support for these amendments is discussed in more detail hereinafter; at this point it is noted that the fortified rim is relatively "thin" so that the tumblers mimic permanent

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glassware, yet it has been found that the rim still can provide stiffness to the vessel like a conventional larger "curled" brim. See, for example, Table 1 of the application as filed at page 31 where it is shown that a solid brim of 0.063 inches provides like rigidity with a curled brim of 0.084 inches.

More importantly, the claimed structure with the fortified rim provides unexpected impact resistance as is seen in Table 3 of the application as filed and described at pp. 60-61:

The tumblers (or tumbler stack in the case of a nested column) were clamped about their bases to be in a free-standing position and a cylindrical suspended weight was positioned to be at rest with its cylinder wall adjacent the rim of the tumbler. The weight was then drawn to a predetermined angle from the vertical and released. The angle with vertical at failure was recorded and the energy dissipated at impact was calculated based on the height to which the cylindrical weight was raised above the rest position.

Utilizing the above procedure, polystyrene cups having the general characteristics of the cups of **Figure 8** ("beaded") were compared with similar cups with a "U" shaped brim. The cups of the invention had a wall thickness of about 15 mils and a bead thickness of 63.7 mils about its brim. Results appear in Table 3, wherein it can be seen the cups of the invention exhibit an energy to failure of nearly twice that of cups with a "U" shaped brim.

Table 3. Pendulum Test Energy to Failure for Beaded and "U" Shaped Brim Polystyrene Cups (Nested Cups)

Cup ID	Pendulum Weight lbs	Pendulum Length inches	Pendulum Angle At Failure Degree	Energy to Failure lb-in	Energy to Failure Average
Beaded	0.941816	25.5	20	1.45	
Beaded	0.941816	25.5	25	2.25	
Beaded	0.941816	25.5	25	2.25	
Beaded	0.941816	25.5	25	2.25	
Beaded	0.941816	25.5	25	2.25	2.09
"U"	0.941816	25.5	20	1.45	
"U"	0.941816	25.5	15	0.82	
"U"	0.941816	25.5	15	0.82	
"U"	0.941816	25.5	15	0.82	
"U"	0.941816	25.5	20	1.45	1.07

As can be seen from the above, the tumblers of the invention had an unexpected increase in impact resistance of nearly 100%. Given this surprising, unexpected and indeed very desirable result, it is believed that the amended claims should be allowed.

The art does not suggest the advantages of the inventive tumblers.

*McChesney et al.* teaches an injection blow-molded bottle with a small opening, not a drinking vessel with an opening larger than its base; nor does *McChesney et al.* remotely suggest the claimed rim structure. So also, *Andersen et al.* '046 and *Kawakami et al.* '439 do not disclose, teach or suggest the claimed tumbler structure; whereas *Willbrandt* teaches a relatively thick rim on the injection molded "car cup" disclosed therein. In particular, *Willbrandt* '337 teaches a preferred upper sidewall thickness of 30 mils (Col. 4, line 31), with a rim having a thickness of 220 mils, Col. 5, line 22. Thus, the rim is disclosed to be more than 7 times the thickness of the adjacent sidewall.

In contrast, the present invention seeks to limit rim width in order to mimic glassware, yet provide for strength and impact resistance. This can be achieved in a blow molded tumbler with rims 6 times or less thickness than the adjacent sidewall. Given that *Willbrandt* teaches: (1) injection molding is preferred, (2) a rim thickness of more than 7 times the adjacent sidewall is preferred, and (3) a thickened "shoulder" is relied upon for strength rather than biaxial orientation achieved through blow-molding, it is believed that all of the amended claims are patentable over *Willbrandt*.

The design of the present invention is further amendable to, and enhanced by, molded-in designs as recited in amended Claims 10 and 30 which claim the triangular ridges of the embodiment of **Figures 3A** and following and the embossed design (see **Figures 1A, 6A**) which provide additional strength and provide utility as a grip to the disposable cup. Here again, the designs mimic permanent glassware in a disposable, relatively thin-walled container having the unique feature that the designs are generally of the same thickness as the rest of the sidewall.

Turning briefly to §112, second paragraph rejections and objections, it is believed the foregoing amendments have made all necessary clarifications and deleted all objectionable language from the claims. Claim 1, for example, has been amended to delete the term “disposable”, and “biaxial toughness”. There has been recited instead that the tumblers are formed from parisons that are expanded in the forming process. One of skill in the art would understand that the tumblers of the invention are both biaxially oriented as well as disposable based on that recitation.

The term “tumbler” as clarified by requiring the mouth is of larger diameter than the base is believed proper. Attached as Exhibit 1 is a relevant dictionary page defining “tumbler” as a drinking vessel without a stem. Likewise, the adjective “fortified” has been supplemented with language defining its structure and the claims specifying a haze value have been eliminated. Accordingly, all claims are believed to have been amended as required.

Support for the amendments to the claims not involving merely combining existing claims is readily found in the text of the application as filed.

The added claim language “characterized by a base diameter”, is supported by the Figures such as **Figure 1**, item “**D**”; *see also* page 21, line 10 and following which also recites the relative diameters such that the opening is of larger diameter than the base. The other added language to Claims 1, 2, 10 and so forth is largely taken from existing claims and is supported throughout the text and drawings as originally filed; further discussion appearing unnecessary except perhaps with respect to the following: (1) the language added to the claims to the effect that the rim is on integral polymer bead is taken from the description at the bottom of page 21 and top of page 22; (2) the language added to Claim 10 with respect to the triangular grooves is found on page 22, line 20 and following of the application as filed; and (3) the added language to Claim 30 concerning the embodiments appears in the text as filed, page 26, line 26. Support for new Claims 90 and 91 is found on page 31 immediately

following Table 1 and **Figure 4B**. **Figure 4B** shows a circular rim profile and the text describes ellipsoid, truncated conic sections and other curved profiles.

Amendments to the drawings are proposed for clarity. The rim design illustrates well in **Figures 4(b)** and **17(c)** schematically; however, is not believed well illustrated in **Figure 1(a)**, for example. Amendments to the drawings are proposed for purposes of showing the rim design most clearly in the case and to correct any obvious numbering errors.

In view of the foregoing amendments and remarks, this application is believed in condition for allowance. If for any reason the Examiner would like to discuss this case, the Examiner is invited to call at the number listed below.

Respectfully submitted,

A handwritten signature in black ink, appearing to read "Mw Ferrell". The signature is fluid and cursive, with the first letters of the first and last names being capitalized and prominent.

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APPENDIX B

(marked-up version of Claims 1, 2, 10, 16, 22, 30, 36, 42, 50, 61, 64-68, 74, 77, 82 and 83 and new Claims 86-89)

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1. (Amended) ~~An injection blow-molded disposable tumbler exhibiting biaxial toughness~~ formed from a polymeric material comprising:

(a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;

(b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead; and

~~(c) wherein said fortified rim has a thickness greater than~~ from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall; and  
wherein the volume of the injection blow-molded tumbler is from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared.

2. (Amended) ~~An injection blow-molded disposable tumbler exhibiting biaxial toughness~~ formed from a polymeric material comprising:

(a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;

(b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

(b)(c)        said sidewall extending upwardly with a taper of from about 1.0 to about 4.5 degrees;  
and

wherein said fortified rim has a thickness of ~~at least 2 mils greater than~~ from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils and  
wherein the volume of the injection blow-molded tumbler is from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared.

10. (Amended) An injection blow-molded disposable tumbler formed from a polymeric material comprising:

- (a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;
- (b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally longer than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;
- (c) ~~said sidewall exhibiting biaxial toughness,~~ the volume of said injection blow-molded tumbler being from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared;

wherein said fortified rim has a thickness of ~~at least 2 mils greater than~~ from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils; and

wherein said tumbler has a taper from about 1.0 to about 4.5 degrees, and



(d) wherein further the sidewall is provided with a molded in design comprising a series of triangular ridges deeper in dimension than the wall caliper thus providing strength by way of corrugation and having a wall thickness the same as the rest of the tumbler.

16. (Amended) An injection blow-molded tumbler formed of an optically clear polymer comprising;

(a) a substantially circular base portion characterized by a base diameter with an outer edge;

~~(b) a substantially cylindrical base portion with an outer edge;~~

(e)(b) a substantially cylindrical sidewall extending upwardly from the outer edge of the base portion having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

said sidewall extending upwardly with an angular taper with its central axis of from about 1.0 to about 4.5 degrees;

said fortified rim having a thickness of ~~at least 2 mils greater than and~~ from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall;

said sidewall further including a pattern which alters the cylindrical character thereof over at least a portion of said sidewall which pattern is operative as a grip portion for a user; and wherein the volume of the injection blow-molded tumbler is from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared.

22. (Amended) An injection blow-molded ~~disposable tumbler exhibiting biaxial toughness~~ formed of a polymeric material comprising:

(a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;

(b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

said sidewall extending upwardly with a taper of from about 2.5 to about 10 degrees;

wherein said fortified rim has a thickness ~~of at least 2 mils greater than~~ of from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils. and

wherein the volume of the injection blow-molded tumbler is from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared.

30. An injection blow-molded ~~disposable~~ tumbler formed of an optically clear polymer comprising:

(a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;

(b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

~~said sidewall exhibiting biaxial toughness,~~ the volume of said injection molded tumbler being from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared;

wherein said fortified rim has a thickness of ~~at least 2 mils greater than~~ of from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils; and

wherein said tumbler has a taper from about 2.5 to about 10 degrees, and

(c) wherein further the sidewall is provided with a design comprised of wall embossments of at least as prominent as  $\frac{1}{2}$  the caliper of the sidewall.

36. (Amended) An injection blow-molded tumbler formed of an optically clear polymer comprising:

(a) a substantially circular base portion characterized by a base diameter with an outer edge;

(b) a substantially cylindrical sidewall extending upwardly from the outer edge of the base portion having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

said sidewall extending upwardly with an angular taper with its central axis of from about 4.5 to about 10 degrees;

said fortified rim having a thickness of ~~at least 2 mils greater than~~ of from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall;

said sidewall further including a pattern which alters the cylindrical character thereof over at least a portion of said sidewall which pattern is operative as a grip portion for a user, and

(c) wherein further the pattern comprises of wall embossments at least as prominent as  $\frac{1}{2}$  the caliper of the sidewall.

42. (Amended) ~~An injection blow-molded disposable tumbler exhibiting biaxial toughness~~ formed of a polymeric material comprising;

- (a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;
- (b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

said sidewall extending upwardly with a taper of from about 1 to about 10 degrees;

wherein said fortified rim has a thickness ~~of at least 2 mils greater than~~ of from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils, said tumbler defining a volume of at least about 16 fluid ounces; wherein the volume of the injection blow-molded tumbler is from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared.

50. (Amended) An injection blow-molded disposable tumbler of an optically clear polymer comprising:

- (a) a base characterized by a base diameter forming the bottom of said tumbler defining an outer edge thereof;
- (b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof having a thickness of from about 5 to about 50 mils defining about its upper extremity an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead;

~~said sidewall exhibiting biaxial toughness~~, the volume of said injection molded tumbler being from about 1.5 to about 4 times the volume of an injection molded parison from which it was prepared and said tumbler defining a volume of from about 16-20 fluid ounces;

wherein said fortified rim has a thickness of ~~at least 2 mils greater than~~ of from about 1.5 to about 6 times the thickness of the adjacent portion of said sidewall over a height of at least 2 mils; and

wherein said tumbler has a taper from about 2.5 to about 10 degrees.

61. (Amended) An injection blow-molded polycarbonate ~~permaware~~ hollow container comprising:

- (a) a base characterized by a base diameter forming the bottom of said container defining an outer edge thereof;
- (b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof and having a thickness of from about over 50 to about 500 mils to an opening having a diameter generally larger than the base diameter provided with a fortified rim integrally formed with the sidewall in the form of a continuous solid polymer bead about its upper extremity; wherein both width and height of the fortified rim are from about 1.1 to about 4 times a thickness of an adjacent sidewall.

64. (Amended) The ~~permaware~~ polycarbonate container of Claim 63, wherein both the width and the height of the fortified rim are about 100 mils and the adjacent sidewall is about 80 mils.

65. (Amended) The ~~permaware~~ polycarbonate container of Claim 61, wherein the base is from about 1.1 to about 8 times the thickness of the sidewall.

66. (Amended) ~~The permaware~~ polycarbonate container of Claim 61, wherein the polycarbonate comprises aromatic homopolycarbonate or aromatic copolycarbonate resins.
67. (Amended) ~~The permaware~~ polycarbonate container of Claim 66, wherein the polycarbonate has a melt flow rate of 10 to 22 g/10 min.
68. (Amended) ~~The permaware~~ polycarbonate container of Claim 61, wherein the bottom of said base has integrally molded thereto indicia or a configuration different from the remaining base.
74. (Amended) ~~A transparent drinking tumbler~~ The injection blow-molded tumbler according to Claim 1, comprised of polystyrene filled with nanometer-sized particles having a size within the range of visible-light wavelengths.
77. (Amended) ~~An injection blow-molded disposable tumbler exhibiting biaxial toughness~~ The injection blow-molded tumbler according to Claim 1, formed from a polymeric material including a copolymer of styrene and butadiene.
82. (Amended) ~~An injection blow-molded disposable tumbler exhibiting biaxial toughness formed from a polymeric material~~ The injection blow-molded tumbler according to Claim 1, including an impact modifier comprising: including an impact modifier
- ~~(a) a base forming the bottom of said tumbler defining an outer edge thereof;~~
  - ~~(b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof defining about its upper extremity a fortified rim; and~~
- (a) wherein said fortified rim has a thickness greater than the adjacent portion of said sidewall, and said impact modifier is selected from the group consisting of core shell polymers, olefin containing copolymers, rubber polymers and copolymers, styrene containing copolymers, and mixtures thereof.

83. (Amended) An injection blow-molded disposable tumbler exhibiting biaxial toughness The injection blow-molded tumbler according to Claim 1, formed from a polymeric material including a mineral filler comprising:

- ~~— (a) a base forming the bottom of said tumbler defining an outer edge thereof;~~
- ~~— (b) a sidewall integrally formed with said base extending upwardly from the outer edge thereof defining about its upper extremity a fortified rim; and~~
- (c) wherein said fortified rim has a thickness greater than the adjacent portion of said sidewall, and wherein said mineral filler is present in an amount of from about 5 to about 50 wt.%.

86. (New) The injection blow-molded tumbler according to Claim 61, comprised of polystyrene filled with nanometer-sized particles having a size within the range of visible-light wavelengths.

87. (New) The injection blow-molded tumbler according to Claim 61, formed from a polymeric material including a copolymer of styrene and butadiene.

88. (New) The injection blow-molded tumbler according to Claim 61, including an impact modifier selected from the group consisting of core shell polymers, olefin containing copolymers, rubber polymers and copolymers, styrene containing copolymers, and mixtures thereof.

89. (New) The injection blow-molded tumbler according to Claim 61, formed from a polymeric material including a mineral filler wherein said mineral filler is present in an amount of from about 5 to about 50 wt.%.

90. (New) The injection blow-molded tumbler according to Claim 1, wherein the polymer bead forming the fortified rim has a curved profile.

91. (New) The injection blow-molded tumbler according to Claim 90, wherein the polymer bead forming the fortified rim has a circular profile.



ANNEX B

(marked-up version of Cover Page of Application)

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For:

INJECTION BLOW-MOLDED DISPOSABLE TUMBLER AND METHOD OF MAKING SAME



#### ANNEX D

(marked-up version of pages 20 and 21 of specification)

Tumbler **10** is optionally provided with a molded-in design **28** which is more clearly seen by reference to **Figures 1(b) and 1(c)**. Base sidewall **26** extends upwardly to define an outer edge **30** which attaches to sidewall **14**. Sidewall **14** extends upwardly to fortified rim **16**. Rim **16** is integrally formed with sidewall **14** and is a continuous generally circular or oval, solid polymer bead extending about periphery **18** of opening **20**. Rim **16** has a width indicated at 31 which is defined by the difference between an inner diameter **32** and an outer diameter **34** of rim **16** and a height **35** which is the distance over which the width indicated at 31 extends. The Width-width at 31 is thicker than adjacent sidewall portion **38** which is typically of the same caliper as the ~~reset~~rest of sidewall **14**. In the example shown in **Figures 1(a) – 1(c)**, adjacent sidewall portion **38** has a thickness of 10 mils, height **35** is approximately 28 mils and the width at 31 is approximately 40 mils at its thickest point.

Annex F  
(marked-up version of pages 21 and 22 of specification)

There is shown in **Figures 2(a) and 2(b)** another tumbler **210** constructed in accordance with the present invention. In general, tumbler **210** has a base portion **212**, a sidewall portion **214** and an upper circular fortified rim portion **216** which extends about the periphery **218** of an opening **220** of tumbler **210**. Base portion **212** of tumbler **210** is integrally formed with the rest of the tumbler and includes a bottom **222** which has a meniscus portion **224** and a base sidewall **226**. Base sidewall **226** is typically thicker than sidewall **214**, and has slightly reversed taper as opposed to the taper of sidewall **214**.

Tumbler **210** is provided with a molded-in design **228** which is a series of concentric rings as shown on **Figures 2(a) and 2(b)**. The dimensions of tumbler **210** are otherwise substantially identical to the dimensions of the tumbler **10** of **Figures 1(a) – 1(c)**.

Annex H  
(marked-up version of pages 23 and 23 of specification)

Base sidewall 326 extends upwardly to define an outer edge 330 which attaches to sidewall 314. Sidewall 314 extends upwardly to fortified rim 316. Rim 316 is integrally formed with sidewall 314 and is a continuous generally circular or oval, solid polymer bead extending about periphery 318 of opening 320. Rim 316 has a width indicated at 331 which is defined by the difference between an inner diameter 332 and an outer diameter 334 of rim 316 and a height indicated at 335 which is the longitudinal distance over which the width at 331 extends. The Width width at 331 is thicker than adjacent sidewall portion 338 which is typically of the same caliper as the rest of sidewall 314. In the example shown, adjacent sidewall portion 338 has a thickness of 20 mils, the height at 335 of the rim is approximately 28 mils and the width at 331 is approximately 40 mils at its thickest point. Other dimensions of tumbler 310 are approximately identical to those of tumblers 210 of **Figures 2(a) and 2(b)** and tumbler 10 of **Figures 1(a) – 1(c)**. Tumbler 310 thus has a taper of 3°.

Annex J

(marked-up version of page 25 of specification)

There is shown in **Figures 6(a) through 6(c)** a tumbler **610** constructed in accordance with the present invention. In general, tumbler **610** has a base portion **612**, a sidewall portion **614** and an upper circular rim portion ~~46~~ **616** which extends about the periphery **618** of an opening **620** of tumbler **610**. Base portion **612** of tumbler **610** is integrally formed with the rest of the tumbler and includes a bottom **622** which has a meniscus portion **624** and a base sidewall **626**. Base sidewall **626** is typically thicker than sidewall **614**, and has either no taper, or a reverse taper from the taper of sidewall **614**.

Annex L  
(marked-up version of page 26 of specification)

Base sidewall 626 extends upwardly to define an outer edge 630 which attached to sidewall 614. Sidewall 614 extends upwardly to fortified rim 616. Rim 616 is integrally formed with sidewall 614 and is a continuous generally circular or oval, solid polymer bead extending about periphery 618 of opening 620. Rim 616 has a width indicated at 631 which is defined by the difference between an inner diameter 632 and an outer diameter 634 of rim 616 and a height shown at 635 which is the distance over which the width indicated at 631 extends. The Width-width 31-631 is thicker than adjacent sidewall portion 638 which is typically of the same caliper as the rest of sidewall 614, that is, sidewall 614 is substantially uniform in thickness on the entire tumbler. In the example shown, adjacent sidewall portion 638 has a thickness of 20 mils, height 635 is approximately 28 mils and width 631 of rim 616 is approximately 40 mils at its thickest point.

Annex N  
(marked-up version of page 27 of specification)

Rim **716** is integrally formed with sidewall **714** and is a continuous generally circular or oval, solid polymer bead extending about periphery **718** of opening **720**. Rim **716** has a width indicated at **731** which is defined by the difference between an inner diameter **732** and an outer diameter **734** of rim **716** and a height shown at **735** which is the distance over which the width indicated at **731** extends. ~~The~~ Width width indicated at **731** is thicker than adjacent sidewall portion **738** which is typically of the same caliper as the rest of sidewall **714**. In the example shown, adjacent sidewall portion **738** has a thickness of 20 mils, height **736** is approximately 28 mils and width **731** is approximately 40 mils at its thickest point.

Annex P

(marked-up version of page 29 of specification)

Base sidewall **826** extends upwardly to define an outer edge **830** which attaches to sidewall **814**. Sidewall **814** extends upwardly to fortified rim **816**. Rim **816** is integrally formed with sidewall **814** and is a continuous generally circular or oval, solid polymer bead extending about periphery **818** of opening **820**. Rim **816** has a width indicated at **831** which is defined by the difference between an inner diameter **832** and an outer diameter **834** of rim **816** and a height shown at **835** which is the distance over which the width indicated at **831** extends. ~~The~~ Width-width at **831** is thicker than adjacent sidewall portion **838** which is typically of the same caliper as the rest of sidewall **814**, that is, sidewall **814** is substantially uniform in thickness on the entire tumbler. In the example shown, adjacent sidewall portion **838** has a thickness of 20 mils, the height at **835** is approximately 28 mils and the width at **831** of rim **816** ~~is approximately 28 mils and width **831** of rim **816** is approximately~~ 40 mils at its thickest point. The tumbler is also provided with a series of molded-in grooves **841** which extend around the tumbler. These grooves provide a grip for a user as well as providing rigidity to the article. ~~Typically, the circumferential grooves **841** have a depth of from **810** to 40 mils.~~

Annex R

(marked-up version of pages 34-35 of specification)

An example of a polycarbonate container in accordance with the present invention is a "bell fountain" container illustrated in **Figures 17(a) - (c)** and is described in detail below. The reusable polycarbonate containers are preferably prepared by the rapidly and economically efficient side-by-side injection blow-molding process as disclosed in aforementioned U.S. 4,540,543. The process is described below in combination with the drawings of **Figures 9-19**. U.S. 4,540,543 is herein incorporated by reference in its entirety. Referring to **Figures 9-11**, injection station **910** is secured in fixed platen **911**. Blow stations **912** and **913** are also secured to fixed platen **911** and are situated adjacent injection station **910** and in side-by-side relationship with respect thereto, with blow station **912** containing blow mold **916** which may be split if desired being on one side of the injection station and blow station **913** containing blow mold **917** which may be split if desired being on the other side. Blow molds **916** and **917** are in the shape of the hollow articles to be made. Ejection stations **914** and **915** are also secured to fixed platen **911** and are situated adjacent the respective blow stations in side-by-side relationship with respect thereto, with ejection station **914** situated adjacent blow station **913** and ejection station **915** situated adjacent blow station **912**. Core **920** is provided secured to movable platen **921** engageable with injection station **910** as shown in **Figure 9**. The injection station **910** includes mold wall **922**. Thus, when core **920** is engaged with injection station **910** as shown in **Figure 9** the core **920** is spaced from the mold wall **922** to form mold cavity **923** therebetween. Injection means **924** is in communication with mold cavity **923** and is connected to a source of hot flowable plastic, i.e., polycarbonate, (not shown) for forcing said hot formable plastic under pressure into mold cavity **923** to form parison **925**. Core **920** is movable into and out of engagement with injection station **910** by movable platen **921** actuated by the motive means shown schematically in **Figure 9** and to be described in more detail herein below. Naturally, the movement of platen **921** may be accomplished by conventional means, shown only schematically in **Figure 9**, which are capable of providing a clamping force between the two platens to keep them from separating during the injection step and the other steps which will be described below. It should be understood that while movement of platen **921** is described, one may of course move platen **911** or both platens **911** and **921**, if desired. The hot, newly formed parison or container **925**



remains in mold cavity 923 until sufficiently cooled to be removed, if desired using cooling means 926 adjacent mold wall 922, as for example, by fluid circulation. If desired, such cooling means may also be provided in core 920. After such cooling of parison 925, the clamping force is released and platen 21 is moved away from platen 11 carrying with it core 920 and parison 925 adhered thereto. If a neck mold is used as to form a threaded neck portion the neck mold is operable by conventional means and remains closed during the formation of the parison, removal of the parison from the injection station and blowing, which also aids in retention of the parison on the core. In the present embodiment, a neck mold is not employed and both the parison and final article have a cup-shaped configuration as seen in the drawings and clearly shown in **Figure 13** and **Figure 17**. In such configuration, the top or mouth of the container (mold) is about as wide or wider than the diameter of the remainder of the container mold. Thus, parison 925 has a base portion 930, a fortified rim or lip 931 and outwardly flaring side walls 932 extending from base 930 to lip 931. Fortified rim 931 may serve as an undercut to aid in retention of the parison on the core. Core 920 is provided with fluid passageway 933 connected to a source of fluid pressure for blowing the final article. If desired, a vacuum may be drawn through passageway 933 to aid in retention of the parison on the core. Core 920 with parison 925 thereon is then moved to blow station 913 as shown in **Figures 10** and **11** in a manner which first separates the parison from the mold wall 922 by moving parison core 920 axially in a straight path away from said mold wall at least until the parison clears the injection station, followed by movement in a substantially arcuate path into axial alignment with blow station 913 and blow mold 917, followed by moving the parison core axially in a straight path into blow mold 917. Parison 925 is then expanded on core 920 in blow mold 917 by fluid pressure through passageway 933 to form hollow article 934. **Figure 9** shows core 920 engaged with the injection station. **Figure 10** shows core 920 with parison 925 thereon removed from the injection station on its arcuate path between injection station 910 and blow station 913 with platen 921 and core 920 at the peak of their arcuate path. **Figure 10-11** shows core 920 engaged with blow station 913 forming hollow article 935 therein. After the formation of hollow article 934, core 920 is removed from blow station 913 leaving hollow article 934 remaining therein and returned to the injection station along paths corresponding to the path taken by core 920 from the injection station 910 to the blow mold 917, that is, the core is moved axially in a straight path away from blow mold 917 followed by movement in a substantially arcuate path into axial

alignment with said injection station, followed by movement axially in a straight path into said injection station for repeat of the cycle.

Annex T  
(marked-up version of pages 37-38 of specification)

In operation, the parison is transferred into blow mold 917 as above described and blown into final shape therein, followed by insertion of mandrel 950 which is shorter than the depth of the blow mold. In order to remove the blown article 934, pusher plate 952 is advanced forcing the blown object onto mandrel 950 which is then withdrawn. If desired, vacuum may be applied through passage 953 better to assure adherence of article 934 to the mandrel during withdrawal from the blow mold. Clearly, pusher plate 952 and the stripper cap 956 may also be used to shape the portion of article 934 between them. If a rim undercut is embedded in the blow mold, it is overcome to effect release from the blow mold by the action of pusher plate 952 which has a stroke at least sufficient for the length of said undercut, it being understood that a given article may exhibit more than one undercut. In this manner, sticking of the finished article to the blow mold is avoided. Subsequently, mandrel 950 carrying article 934 is aligned with removal devices as described above and, since all relative movement between the mandrel and the blow mold may be precluded due to the close fit of the mandrel and the article at the neck of the article, which may be an interference fit or an undercut, and, if necessary due to the vacuum, the alignment will be consistent from cycle to cycle. Upon alignment with the ejection station, the vacuum if theretofore applied through channel 953 is released and stripper 954 is actuated to urge the article into engagement with the ejecting device by positive mechanical means. The advantage of this arrangement compared to previous practice is in its reliability, preventing interruptions of the operation and thereby improving efficiency. While the foregoing description shows a single injection mold and core set, it will naturally be understood that multiple injection mold and core sets may readily be employed, for example, arranged side-by-side or in several rows. Thus, it can be seen that the process and apparatus of U.S. 4,540,543 obtains significant advantages. The overlapping cycles enable plural operations to be conducted simultaneously. While core 90920 is engaging injection station 910 to form a first parison, second core 940 is engaging blow mold 916 to form a final article 934, second ejection core 951 is ejecting a hollow article at ejection station 915 and ejection core 950 is engaging a hollow article at blow station 913 for removal thereof, with the axial, arcuate and axial movement described hereinabove providing a considerable advantage in reduction in cycle time which of

course is a prime consideration in this art. The so-called "dry cycle" is that part of the total operating cycle of the apparatus described in **Figures 9-11** which is not attributable to process related factors but only to the mechanism.

Annex V  
(marked-up version to pages 39-41 of specification)

In accordance with the present invention, however, the axial, arcuate and axial movement substantially reduces the dry cycle time and thus reduces the overall cycle time. Referring to **Figure 11**, the movements of movable platen **921** are shown diagrammatically, which will of necessity include the movement of the cores thereon. Thus, when platen **921** moves from the position in **Figure 9** to the position in **Figure 11** a given point on the platen will follow curve A. The return movement will follow curve B. As platen **921** moves away from platen **911** the section on curve A from location **960** to **961** represents movement from the closed position of **Figure 9** to that point at which movement of core **920** with parison **925** thereon may occur laterally without mechanical interference. As soon as location **961** is passed said point starts its lateral movement which is subdivided into three (3) sections, namely between locations **961** and **962** in which acceleration is taking place, then between **962** and **963** in which the velocity of the point is constant, followed by between **963** and **964** in which deceleration is taking place. Finally, locations **964** and **965** show the approach to the blow mold and the position shown in **Figure 16**. Naturally, the actual shapes of the curve segments will depend on the mass being moved, with the segment being steeper the lighter the movement assembly. As indicated above, curve B depicts the reverse movement. These movements can be effected by any conventional means, e.g. fluid actuators or by cam action. If by fluid actuators, it is readily possible to initiate their movement and thus also that of platen **921** by a limit switch placed to be tripped by platen **921** as soon as said platen reaches the distance from platen **911** at which the lateral movement of core **920** can take place unimpeded. If by cam action, fixed cams in the shape of curves A and B of **Figure 16** may be used and platen **911** may be equipped with corresponding cam followers, to the effect that the axial movement of platen **921** will at the same time induce its lateral movement according to the cam path. Other means to produce the same result may be employed so long as the lateral movement of platen **921** is effectively controlled by its axial movement, whereby said lateral movement accommodates acceleration and deceleration of platen **921** according to the mass to be moved therewith. The advantage of this improved arrangement is evident from the gain in cycle time. Thus, in the case referred to hereinabove the dry cycle of the injection clamping apparatus is reduced from approximately 4 seconds to approximately 1.2 seconds,

of which the lateral shifting of platen **921** takes only 0.4 to 0.5 seconds including acceleration and deceleration. This improvement is particularly noticeable in connection with mechanical, e.g. toggle or crank clamping mechanisms which are favored for rapid acting injection clamps over fluid actuated clamps. In the former, the clamping apparatus, which is of the "fixed stroke" type can be used to induce the movement of platen **21** during that portion of its opening and closing stroke respectively which is in excess of the minimum clearance between core **920** and mold **917**. Cores **920** and **940** are equipped with fluid passageways terminating in so-called blow slots **970** as shown in **Figure 14** in order to effect blowing of the preforms in the blow molds, as is known in the art. If permanently open, the blow slot **970** is connected according to conventional design of a source of pressure fluid and a source of vacuum via fluid passageway **978** whereby the change from one to the other is effected by a conventional valve in order for the dual function of the blow slot to be readily accomplished as needed during injection and opening of the injection mold, and then during blowing. The blow slot may be formed of two elements of the core, for example leading element **971** and following element **972**, that are capable of relative movement as shown in **Figure 14** by the arrow, with **Figure 11** showing leading element being relatively moveable, with element **971** having a leading bulb-like portion **973** connected to a movable stem **974** which in turn is connected to a motive means (not shown). It is necessary to control the opening and closing of blow slot **970** mechanically in the following sequence: the blow slot is closed and held in that condition while injection of the plastic into the mold is initiated and almost immediately thereafter is opened; alternatively, it may be kept closed until the filling of the mold is accomplished and opened only thereafter. Vacuum is applied while the blow slot is open and maintained as core ~~20~~ **920** or ~~40~~ **940** is moved away from injection station **910** (see **Figures 9 and 10**). The blow slot remains open and vacuum is maintained while the preform moves from the injection station into the blow station, at which time, by suitable valving, the vacuum is broken and fluid pressure applied inside the preform to expand it into the shape of the finished article. At the end of the blowing cycle, the connection between the blow slot and the source of fluid pressure is interrupted, but vacuum is not admitted inside the finished article. Accordingly, in the case of an operable slot, the flow of fluid or connection to vacuum is controlled by a valve system that operates as follows: open to vacuum; closed to vacuum, open to pressure, closed to pressure, open to atmosphere, closed to pressure, closed to vacuum; blow slot closed **Figure 15** shows one embodiment of actuating the blow slot **970**. As shown, a spring **975** is provided, urging the movable element **971** forming the blow slot to open the

latter. Stem **974** is provided with a fixed annular bar **976**. Spring **975** is affixed to stem **974** between bar **976** and internal ridge **977** on element **972**. When inserted into the injection station, the entering plastic will tend to counteract the force of spring **975** closing the blow slot. When the pressure of the entering plastic is relieved, spring **975** will tend to open the slot again. However, if no vacuum is applied, then atmospheric pressure will tend to close the slot or counteract the spring. Accordingly, the spring force chosen has to be such as to maintain the blow slot open against the atmospheric pressure so that vacuum may be applied.

Annex X  
(marked-up version of pages 43-45 of specification)

In accordance with this invention, namely the manufacture of a bell fountain drinking cup as illustrated in **Figure 17(a)** from polycarbonate, the following process parameters can be used with the blow-molding apparatus and process as described in U.S. 4,540,543 and above. Initially, the polycarbonate in the form of pellets is dried to remove moisture. Drying conditions of 3.5 hours at 250°F have been found useful in providing a polycarbonate which can be injection blow-molded into the permaware containers of this invention. The polycarbonate plastic has to be pressure formed into the parison rapidly, hence the molten plastic temperature is left relatively high at from about 450°F to about 700°F, preferably, from about 500°F to about 650°F; and most preferably, a temperature of about 545°F has been found to yield the desired parison. Injection pressures of 1,000 to 3,000 psi can be used, with an injection pressure of about 2,100 psi being most preferred. The parison has to be removed from the parison mold after the shortest possible dwell therein in order to rapidly proceed to the next molding cycle, yet without tending to adhere to the mold and become deformed thereby. For permaware, which require a thicker parison, the time in the parison mold must yield a stable parison. Dwell times in the parison mold to produce the polycarbonate permaware of this invention range from about 1 to 3 seconds, with 2.5 seconds being most preferred. In general, the temperature of the parison has to reach a level suitable for orientation during the short dwell in the parison mold and the comparatively short time, shortened by the clamp action described herein, during which the parison is transported into the blow mold. The temperature at which the deformation of the parison, i.e., blowing takes place, should be uniformly maintained while the parison is expanding and until it contacts the parison mold. Temperatures ranging from about 250°F to about 500°F, and most preferably at about 285°F can be used. In no case must the parison be damaged, nor deformed in the course of any operation to which it is subjected, except of course blowing. A blowing pressure of from about 100 to about 500 psi, preferably, from about 200 to about 400 psi, and most preferably at about 250 psi, is employed. **Figures 17(a)** through **17(c)** illustrate a bell fountain tumbler 979 injection blow-molded in accordance with the present invention. The tumbler can be prepared using a split blow cavity employing two separate halves which can be configured exactly the same or differently to provide separate design elements to the



tumbler. For example, tumbler 979 can optionally be provided with an embossing design defined by embossed flat surfaces 988 and ridges 1004 which circumscribe the embossed areas 988. The design is operative as a grip for a user since the smooth sidewall is substantially altered. Such tumblers are typically characterized by a seam 1001 along the longitudinal axis of the tumbler. The tumbler 979 has a base portion 980, a sidewall portion 981 and an upper circular rim portion 982 which extends about the periphery 983 of an opening 984 of tumbler 979. Base portion 980 of tumbler 979 is integrally formed with the rest of the tumbler and includes a bottom 985, a base sidewall 987, and an inner face 989 attached integrally to sidewall 981. Tumbler 979 as shown is characterized as a "bell fountain" tumbler in which sidewall 981 extends upwardly to convex portion 990 which extends to concave portion 991 and extends to fortified rim 982. Rim 982 is integrally formed with sidewall 981 and is a continuous generally circular or oval, solid polymer bead extending about periphery 983 of opening 984. Rim 982 has the advantages that it is rounded and does not snag on the mold or snag with a cup cover as a top curl does. For another advantage, a bead type top rim can more compactly provide rigidity and strength to a cup than does a top curl, with less width. While polymer bead rim 982 is shown as circular in cross section, other profiles may be suitable for example, conic sections such as ellipsoid shapes or truncated conic sections or profiles such as truncated conic sections including a semi-circle or a half ellipse. Rim 982 has a width **W** which is defined by the difference between an inner diameter 993 and an outer diameter 994 of rim 982 and a height **H** which is the distance over which width **W** extends. Width **W** is thicker than the rest of sidewall 981. Sidewall 981 is substantially uniform in thickness on the entire tumbler. In a preferred form of the bell fountain tumbler shown, sidewall 981 has a thickness of 80 mils, height **H** is approximately 100 mils and width **W** of rim 982 is approximately 100 mils. Also, base sidewall 987 preferably has a height or thickness of about 100 mils. While the base sidewall 987 can have a height up to 8 times the thickness of sidewall 981, it has been found that under harsh washing conditions, the base tends to deteriorate if it is about 150 mils or more in the polycarbonate tumbler shown. The overall height of the preferred tumbler 979 is 6.625 inches, inner diameter 993 is 3.25 inches, base diameter is 2.325 inches and shoulder 990 has an inner diameter of 3.5 inches. As noted above, tumblers in accordance with the present invention are produced by injection blow-molding thermoplastic optically transparent polymers.

Annex Z  
(marked-up version to pages 45 and 46 of specification)

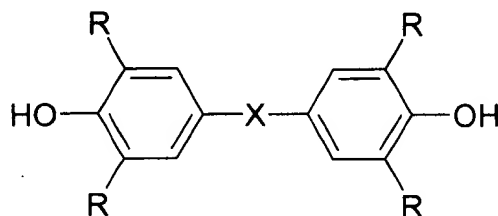
Referring to **Figure 17(b)**, it can be seen that the bottom of base **985** has been molded to include a concave, flat portion **986** which includes a rim **1005**, both of which locations can be used to imprint product identifying indicia (not shown). **Figure 17(b)** also shows where a lug **1006** has been molded into the bottom **985** of base **980**. Molded lug **1006** can be used to align the tumbler during any subsequent printing operation. Previous to this invention, the incorporation of such molded indicia or components to the base of a blow-molded article, in particular, an article in which the wall thickness was greater than 50 mil, required a separate noncontinuous step in which the article, such as a tumbler needed to be taken from the blow mold at an elevated temperature, and conveyed by a separate conveyor structure to a stamping operation. For relatively thick walled structures including those having a wall thickness of greater than 50 mils, the molding of the indicia could not take place during blow-molding since the fluid pressure during the blowing step could not press the parison to be molded sufficiently hard against a mold surface to provide acceptable indicia or deep structural configurations to the surface such as the printing lug **1006** shown in **Figure 17(b)**. In a novel aspect of the present invention, the polycarbonate tumbler of the present invention can be blow-molded and the base thereof reconfigured in a continuous manner without the need to remove the tumbler from the blow mold and convey the tumbler away from the apparatus to a separate stamping operation. The base molding method and apparatus which are novel to the present invention can be described by referring to **Figure 18**. Thus, after removal of the core from the blow-molding station, as described above, an alternative ejection core can be inserted into the blow cavity which contains the blow-molded container. This alternative ejection core provides a slight pressure against the inside surface of the container pressing the bottom surface of the container against a preformed mold. More specifically, shown in **Figure 18** is the blow cavity ~~1010~~ of a blow mold 110 such as a blow station **913** as shown in **Figure 11**. Within the blow cavity is the blow-molded tumbler **1012** which includes a sidewall **1014** and a base **1016** which has a bottom surface **1018** which is to be provided with indicia or other structural configurations such as printing lug **1006** as shown in **Figure 17(b)**.

Annex BB  
(marked-up version of pages 46-50 of specification)

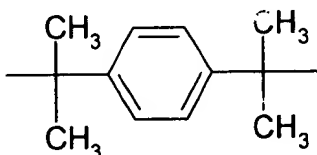
In accordance with the molding operation of the present invention, after the blow-molding step and once the core has been removed from the blow mold **1010** of **Figure 18**, for example, an ejection core **1020** is inserted into the blow cavity ~~1010~~ and the tumbler **1012** which remains therein. Ejection core **1020** is wide enough to contact the inside edge of sidewall **1014** near or at the base **1016** of tumbler **1012**. Such contact is shown at location **1022**. Bottom edge **1024** of ejection core **1020** contacts the inside surface of base **1016** and pushes the tumbler **1012** against a mold **1026**. Ejection core **1020** can also include a circumferential lip **1021** which engages the lip **1013** of tumbler **1012** so as to aid in pushing tumbler **1012** uniformly against the surface of mold **1026**. In **Figure 18**, mold **1026** is shown containing a mold configuration **1028** which is capable of forming a printing lug on the bottom **1018** of base **1016** such as equivalent to printing lug **1006** shown in **Figure 17(b)**. Mold **1026** can be secured to blow cavity **1010** via threaded connector **1027**. It has been found that the mechanical pressure of ejection core **1020** against the inside surface of base **1016** provides adequate pressure against the mold **1026** to adequately stamp any indicia or other configuration into the base of the tumbler. Typically, the pressure of the ejection core **1020** against the base **1016** within the blow cavity to mold or stamp the base takes approximately 0.5 second. Mold **1026** can include a cooling channel **1030** to provide the cooling of the base subsequent to the molding operation. Likewise, ejection core **1020** can also be provided with a cooling channel **1032**. In each of cooling channels **1030** and **1032**, cooling fluids such as water can be circulated therein to provide the proper temperature. Subsequent to the molding or stamping operation, the ejection core **1020** is removed from the blow cavity. Since the mandrel **1020** contacts the inside sidewall **1014** of tumbler **1012**, the tumbler is removed from the blow cavity as well and transferred to any conveying station as described previously. The ejection core **1020** is an alternative to the ejection core **950** shown in **Figures 11, 12 and 13** and can be attached to a motive means as described above with respect to core **950** to provide a continuous process of injection blow-molding and molding the base of the tumbler. Another improvement in this invention for injection blow-molding permaware polycarbonate tumblers in which a sidewall thickness of greater than **950** mils is provided is shown in **Figure 19**. **Figure 19** is an alternative blow mold cavity configuration which is different than,

for example, the blow cores shown in **Figures 14 and 15**. Thus, in the previous description, blowing of the parison into the molded tumbler was achieved by directing fluid through a blow slot in the core which directed the fluid at the base of the parison mold. Subsequently, the fluid pressure would work its way up the mold and be vented from the entrance of the mold. With respect to the tumbler, the initial fluid pressure would be at the base of the tumbler and work its way along the sidewall to the tumbler opening. In accordance with this invention, it has been found that a uniform blow-molded tumbler can be better achieved by directing the fluid pressure during the blow stage from the top of the mold and working down toward the base of the blow cavity or, with respect to the tumbler, blowing the parison at the opening of the tumbler and working down toward the base of the tumbler. Such configuration is shown in **Figure 19** which includes a blow cavity mold **1040** into which has already been inserted the core **1042** which contains the injected molded parison **1044** contained along the outside surface of core **1042**. The blow cavity mold **1040** includes a mold surface **1046** in the shape of the bell fountain tumbler shown in **Figure 17(a)**. The core **1042** includes a blow vent **1048** which releases a fluid into the mold ~~1046~~ of blow cavity **1040** near the entrance thereof or with respect to the tumbler, near the opening of the tumbler. The fluid pressure travels down the core **1042** blowing and pressing the parison **1044** against mold surface **1046** from the top of the parison to the base **1050** of the parison. Blow cavity mold **1040** also includes the base mold **1026** as described in **Figure 18** which allows the molding of the base of the blow-molded tumbler once core **1042** is removed and ejection core **1020** is inserted. Mold **1026** includes a vent **1052** connected to the blow cavity ~~1040~~ to vent excess fluid pressure. It has been found that a more uniform sidewall can be achieved by blowing from the opening of the parison/tumbler to the base thereof. This method of blowing the parison has previously been done to blow polystyrene disposable containers but is not believed to have been done with resins other than polystyrene and not to form permaware tumblers having sidewall thicknesses of greater than 50 mils. The reusable containers of the present invention are formed from aromatic polycarbonates preferably having a weight average molecular weight of from about 10,000 to 200,000, most preferably from about 20,000 to 80,000, and most particularly a melt flow rate range of from about 10 to 22 g/10 min (ASTM D-1238) and which are prepared by methods known to those skilled in the art and more particularly by methods disclosed in U.S. Pat. Nos. 3,028,365, 2,999,846, 3,248,414, 3,153,008, 3,215,668, 3,187,065, 2,964,794, 2,970,131, 2,991,273 and 2,999,835, all incorporated herein by reference. The aromatic polycarbonates useful in practice of the invention are produced by reacting di-(monohydroxyaryl)-alkanes (bisphenols) or

dihydroxybenzenes and substituted dihydroxybenzenes with derivatives of carbonic acid such as carbonic acid diesters, phosgene, bis-chlorocarbonic acid esters of di-(monohydroxyaryl)-alkanes and the bis-chlorocarbonic acid esters of the dihydroxy-benzenes and the substituted dihydroxy-benzenes. By aromatic polycarbonate, in the sense of the present invention, there are understood homopolycarbonate and copolycarbonate resins which are based, for example, on one or more of the following bisphenols: hydroquinone, resorcinol, dihydroxydiphenyls, bis-(hydroxyphenyl)-alkanes, bis-(hydroxyphenyl)-cycloalkanes, bis-(hydroxyphenyl)-sulphides, bis-(hydroxyphenyl)-ethers, bis-(hydroxyphenyl)-ketones, bis-(hydroxyphenyl)-sulphoxides, bis-(hydroxyphenyl)-sulphones and  $\alpha$ ,  $\alpha$ -bis-(hydroxyphenyl)-diisopropylbenzenes, as well as their nuclear-alkylated and nuclear-halogenated compounds. These and further suitable aromatic dihydroxy compounds are described, for example, in U.S. Pat. Nos. 3,028,365, 2,999,835, 3,148,172, 3,271,368, 2,991,273, 3,271,367, 3,280,078, 3,014,891 and 2,999,846 (all incorporated herein by reference), in German Offenlegungsschriften (German Published Specifications) 1,570,703, 2,063,050, 2,063,052, 2,211,956 and 2,211,957, in French Patent Specification No. 1,561,518 and in the monograph "*H. Schnell*, Chemistry and Physics of Polycarbonates, Interscience Publishers, New York, 1964". Preferred bisphenols are those of the formula I:



in which R is identical or different and denotes H, C<sub>1</sub>-C<sub>4</sub>-alkyl, Cl or Br; preferably H or C<sub>1</sub>-C<sub>4</sub>-alkyl, and in which X is a bond, C<sub>1</sub>-C<sub>8</sub>-alkylene, C<sub>2</sub>-C<sub>8</sub>-alkylidene, C<sub>5</sub>-C<sub>15</sub>-cycloalkylene, C<sub>5</sub>-C<sub>15</sub>-cycloalkylidene, -S-, -SO<sub>2</sub>-, -SO-, -CO- or



Annex DD

(marked-up version of pages 57-58 of specification)

The base molding method and apparatus which are novel to the present invention in one embodiment can be described by referring to **Figure 18**. Thus, after removal of the core from the blow-molding station, as described above, an alternative ejection core can be inserted into the blow cavity which contains the blow-molded container. This alternative ejection core provides a slight pressure against the inside surface of the cup pressing the bottom surface of the cup against a preformed mold. More specifically, shown in **Figure 18** is the ~~a blow cavity 1010~~ of a blow mold such as ~~a~~ at blow station **913** as shown in **Figure 11**. Within the blow cavity is the blow-molded tumbler **1012** in the form of a “bell fountain” tumbler which includes a sidewall **1014** and a base **1016** which has a bottom surface **1018** which is to be provided with indicia or other structural configurations such as a printing. In accordance with the molding operation of the present invention, once the core has been removed from the blow mold **1010** subsequent to the blowing step, an ejection core **1020** is inserted into the blow cavity ~~1010~~ and the tumbler **1012** which remains therein. Ejection core **1020** is wide enough to contact the inside edge of sidewall **1014** near or at the base **1016** of tumbler **1012**. Such contact is shown at location **1022**. Bottom edge **1024** of ejection core **1020** contacts the inside surface of base **1016** and pushes the tumbler **1012** against a mold **1026**. Ejection core **1020** can also include a circumferential lip **1021** which engages the lip **1013** of tumbler **1012** so as to aid in pushing tumbler **1012** uniformly against the surface of mold **1026**. In **Figure 18**, mold **1026** is shown containing a mold configuration **1028** which is capable of forming a printing lug on the bottom **1018** of base **1016**. Mold **1026** can contain other mold features including indicia or trademark logos and the like. Mold **1026** can be secured to blow cavity ~~mold~~ 1010 via threaded connector **1027**. It has been found that the mechanical pressure of ejection core **1020** against the inside surface of base **1016** provides adequate pressure against the mold **1026** to adequately stamp any indicia or other configuration into the base of the tumbler. Typically, the pressure of the ejection core **1020** against the base **1016** within the blow cavity to mold or stamp the base takes approximately 0.5 second. Mold **1026** can include a cooling channel **1030** to provide the cooling of the base subsequent to the molding operation. Likewise, ejection core **1020** can also be provided with a cooling channel **1032**. In each of cooling channels **1030** and **1032**, cooling fluids

such as water can be circulated therein to provide the proper temperature. Subsequent to the molding or stamping operation, the ejection core **1020** is removed from the blow cavity. Since the mandrel **1020** contacts the inside sidewall **1014** of tumbler **1012**, the tumbler is removed from the blow cavity as well and transferred to any conveying station as described previously. The ejection core **1020** is an alternative to the ejection core **950** shown in **Figures 11, 12 and 13** and can be attached to a motive means as described above with respect to core **950** to provide a continuous process of injection blow-molding and molding the base of the tumbler.

Annex FF  
(marked-up version of pages 58-59 of specification)

Another improvement relative to U.S. 4,540,543 is shown in **Figure 19**. **Figure 19** is an alternative blow mold cavity configuration which is different than, for example, the blow cores shown in **Figures 14** and **15**. Thus, in the previous description, blowing of the parison into the molded tumbler was achieved by directing fluid through a blow slot in the core which directed the fluid at the base of the parison mold. Subsequently, the fluid pressure would work its way up the mold and be vented from the entrance of the mold. With respect to the tumbler, the initial fluid pressure would be at the base of the tumbler and work its way along the sidewall to the tumbler opening. In accordance with this invention, it has been found that a uniform blow-molded tumbler can be better achieved by directing the fluid pressure during the blow stage from the top of the mold and working down toward the base of the blow cavity or, with respect to the tumbler, blowing the parison at the opening of the tumbler and working down toward the base of the tumbler. Such configuration is shown in **Figure 19** which includes a blow cavity mold 1040 into which has already been inserted the core **1042** which contains the injected molded parison **1044** contained along the outside surface of core **1042**. The blow cavity mold 1040 includes a mold surface **1046** in the shape of the bell fountain tumbler. The core **1042** includes a blow vent **1048** which releases a fluid into the mold 1046 of blow cavity 1040 near the entrance thereof or with respect to the tumbler, near the opening of the tumbler. The fluid pressure travels down the core **1042** blowing and pressing the parison **1044** against mold surface **1046** from the top of the parison to the base **1050** of the parison. Blow cavity **1040** also includes the base mold **1026** as described in **Figure 18** which allows the molding of the base of the blow-molded tumbler once core **1042** is removed and ejection core **1020** is inserted. Mold **1026** includes a vent **1052** connected to blow cavity mold 1040 to vent excess fluid pressure. It has been found that a more uniform sidewall can be achieved by blowing from the opening of the parison/tumbler to the base thereof. This method of blowing the parison has previously been done to blow polystyrene disposable containers but is not believed to have been done with resins other than polystyrene and not to form permaware tumblers having sidewall thicknesses of greater than 50 mils.



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Second College Edition

The  
**American Heritage  
Dictionary**



tulio

**tuck**¹ (tùk) v. tuckered, tuck-ing, tucks. —tr. 1. To make one or more folds in. 2. To gather up and fold, thrust, or turn in in order to secure or confine: *tuck a scarf into a shirt*. 3. a. To put in a snug spot. b. To put in an out-of-the-way and snug place: *a cabin tucked among the pines*. c. To store in a safe spot: *save: tuck away a bit of lace; tuck away millions*. 4. To draw in; contract. —in-tr. To make tucks. —phrasal verb. tuck in (or away). Informal. To consume (food) heartily. —n. 1. A flattened pleat or fold, esp. a very narrow one stitched in place. 2. The act of tucking. 3. *Naut.* The part of a ship's hull under the stern where the ends of the bottom planks come together. 4. *Cheffy Brit. Slang.* Food, esp. sweets and pastry. 5. a. A bodily position used in some sports, as diving, in which the knees are bent, the thighs are drawn close to the chest, and the hands are clasped around the shins. b. A position in skiing in which the skier squats while holding the poles parallel to the ground and under the arms. [ME *rucken* < OE *rucian*, to [torment].]

3. *Archaic*. Guardianship. (ME *tuicion*, protection < OFr. <

3. Overblown; bombastic: *tumid political prose*